

Date: Tuesday, 1/16/2007 11:28:36 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEM	
Job Number	: 30275A		Part Number	: D29683	
Estimate Number	: 10399		Drawing Number	: D2968	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 1/16/2007		Drawing Revision	: B1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 1/30/2007	
Previous Run	: 29353A		Qty:	40	Um: Each
Written By			Comment	: Est:C 03.04.11 Reformat; Incorporated D2968-1/5 KJ/RF	
Checked & Approved By					
Comment					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M4130NR0750	4130 steel rod .750"	
		Comment: Qty.: 0.3762 f(s)/Unit Total : 15.0486 f(s) Material: AISI 4130 Ø 3/4 " Bar (M4130N-R0.750) Identify AS D2968-3	Batch: M103090 5.8" M171091 10'  8.80/05/02
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL 1-Turn Blank as per Folio FA048 and Dwg D2968 2-Deburr, no sharp edges	DP07/05/12 36/ 8.80/05/02
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	QC / DS/07/05/12 43
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA048 and Dwg D2968 2- Deburr	JL 07/05/14 AF
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	JL 07/05/14 47

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEM

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC8

SECOND CHECK



Comment: SECOND CHECK

Amk 07/05/14 474

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/05/14 (47)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(47)

Comment: FINAL INSPECTION/W/O RELEASE

07/05/14

Job Completion



U 07/05/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

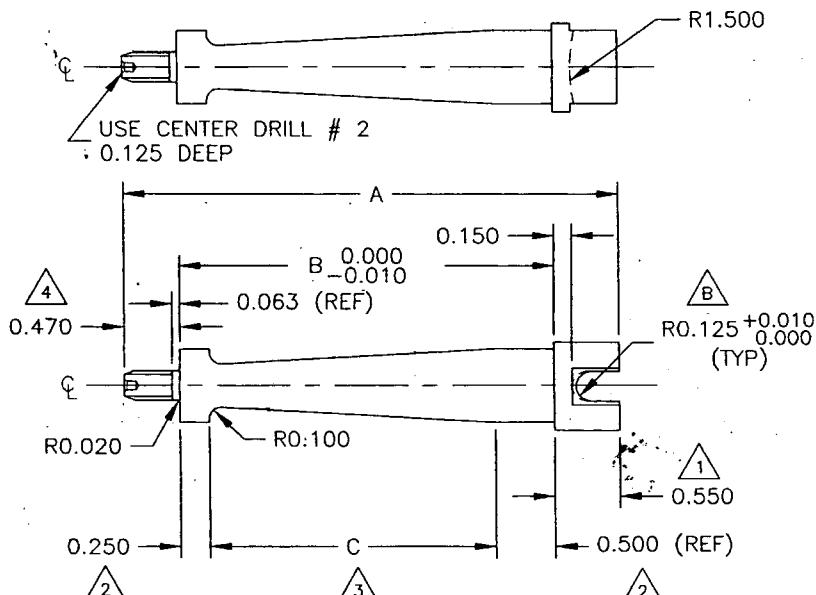
DART AEROSPACE LTD	Work Order:	30275A
Description: Stem	Part Number:	D2968-3
Inspection Dwg: D2968	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>S.P / J.L</u>	Audited by: <u>One</u>	Prototype Approval:	N/A
Date: <u>07/05/02</u>	Date: <u>07/05/04</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	P/O D2968-043	KJ/RF



PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

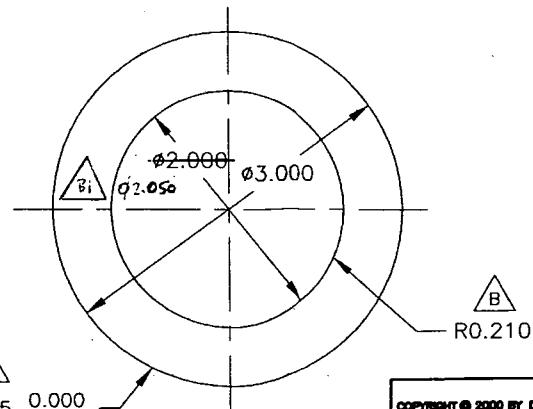
D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

MATERIAL: AISI 4130
 1) Ø0.750 O.D.
 2) Ø0.625 O.D.
 3) MACHINE UNIFORM TAPER FROM Ø0.363 O.D.
 TO Ø0.625 O.D.
 4) 1/4-28 UNF THREAD WITH 0.063 GRIP
 MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 UNLESS OTHERWISE INDICATED
 TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED

D2968-5 RING:

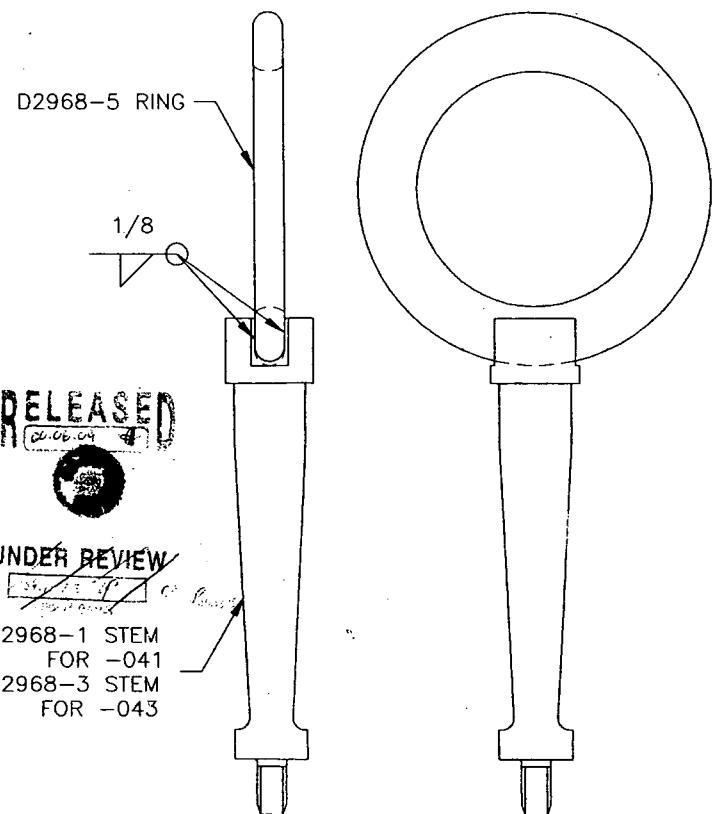
MATERIAL AISI 4130
 TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED



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WORK ORDER
 NO. 30275A
 SUBJECT TO AMENDMENT
 WITH-OUT NOTICE

D2968-5 RING



USE 2968-1 STEM
 FOR -041
 USE 2968-3 STEM
 FOR -043

D2968-041 AND D2968-043 TOW RING:
 WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
 HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI
 FINISH: CAD PLATE ENTIRE ASSEMBLY PER
 QQ-P-416F CLASS I TYPE II
 POWDER COAT WHITE (REF 4.3.5.2) PER DART
 QSI 005 4.3 (EXCEPT THREADS)
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	DRAWN BY	DART
RECHECKED	APPROVED	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
DATE	TITLE	SCALE
00.05.31	TOW RING	1:1

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